

Date: Friday, 02/05/2008 10:47:45 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BEARING		
Job Number	: 38995			Part Number	: D312123		
Estimate Number	: 10089			Drawing Number	: D3121 REV E		
P.O. Number	:			Project Number	: N/A		
This Issue	: 02/05/2008	S.O. No. :		Drawing Revision	: E		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: PURCHASED PARTS	Due Date	: 15/05/2008	Qty:	200 Um: Each
Previous Run	: 38591						
Written By							
Checked & Approved By	: <u>JDO 08-5-02</u>						
Comment	: Est. A: 04.02.19 New Issue KJ/DS Est Rev:B ECN 1060 07-11-12 DD verified by:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
<b>Comment:</b> PURCHASING Issue P/O: <u>60285</u> <span style="margin-left: 100px;"><i>C208105/02</i>            Bearing as per Dwg D3121            Possible Supplier: SKF P/N: 61900-2Z or KML P/N: 6900-ZZ            Material release note is required         </span>		
2.0	6900ZZ	Bearing
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s) Bearing		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
<b>Comment:</b> PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached		
4.0	QC6	DIMENSIONAL CHECK
<b>Comment:</b> DIMENSIONAL CHECK Inspect dimensions as per Dwg D3121 and attached certification Dwg Rev <u>E</u> <span style="margin-left: 100px;"><i>2005/05/02 (x20)</i> </span>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: <u>67</u> <span style="margin-left: 100px;"><i>8/5/06</i> <span style="margin-left: 100px;"><i>2005/05/02 (x20)</i> <span style="margin-left: 100px;"><i>30</i> </span></span></span>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 02/05/2008 10:47:45 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 38995

Part Number: D312123

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/06 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

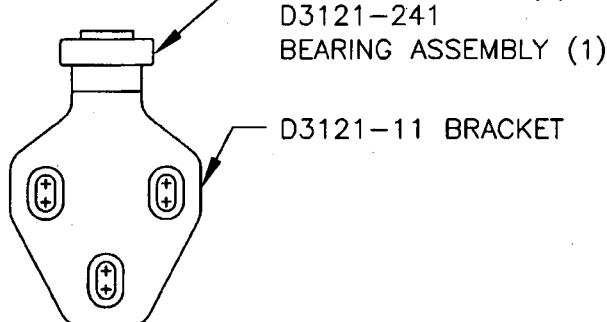
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

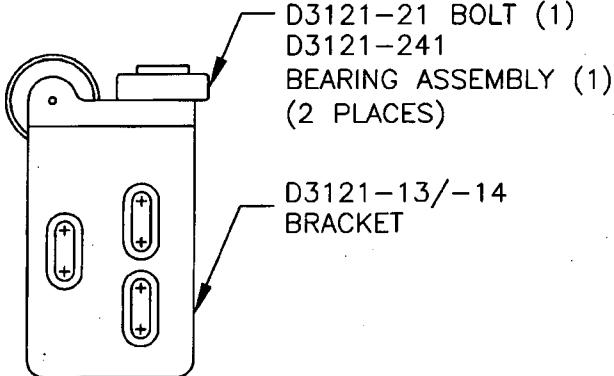
**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>LE</i>	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
(07.11.07) *WAD*

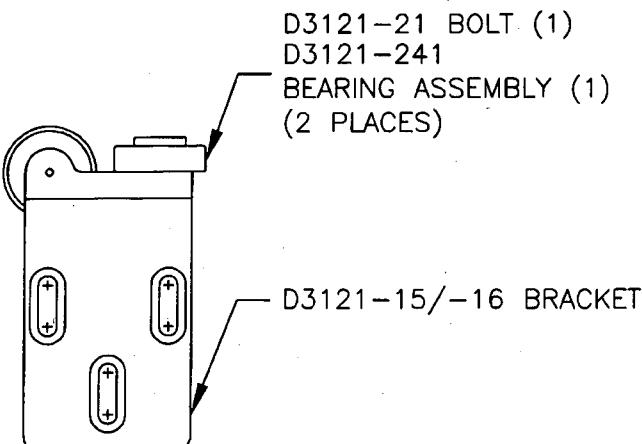
D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)

**D3121-041 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-33)



D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)  
(2 PLACES)

**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)  
(2 PLACES)

**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-35/-36)

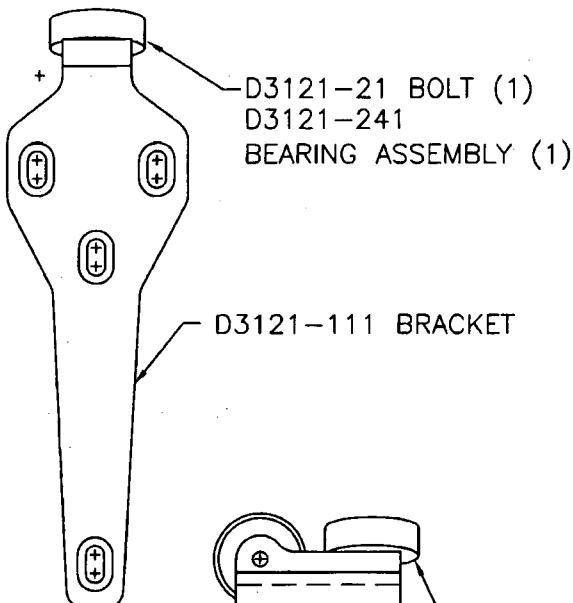
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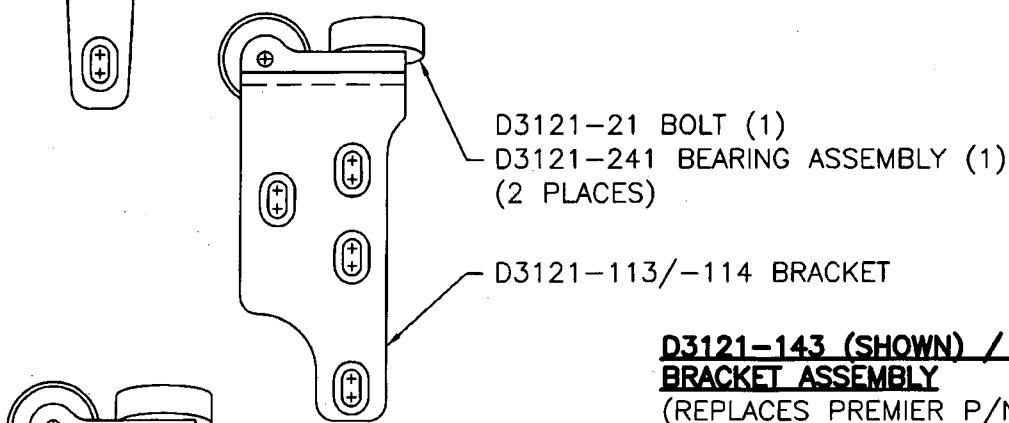
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DATE 07.11.07	TITLE BRACKET ASSEMBLY	REV. E SHEET 2 OF 10 SCALE 1:2

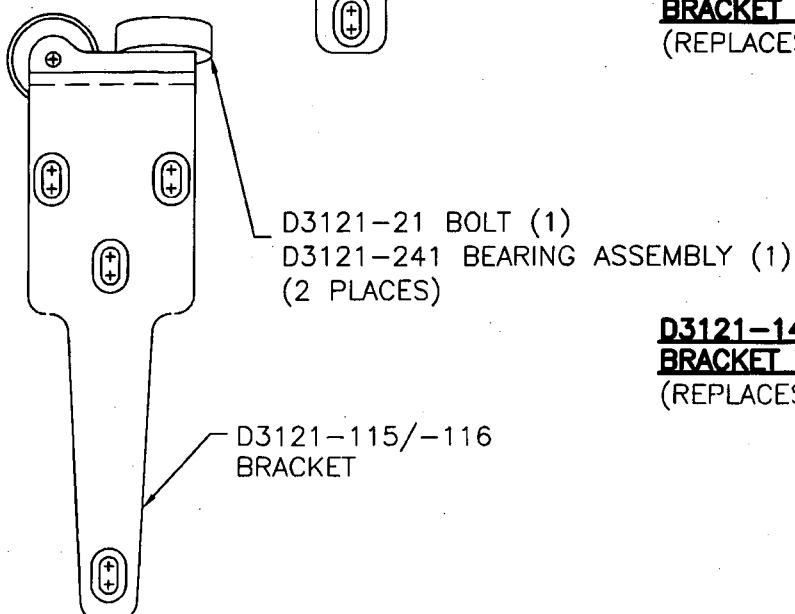


**D3121-141 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23001-01)

**RELEASED**  
*07.11.07 W*



**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-03/-04)



**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000P05/-06)

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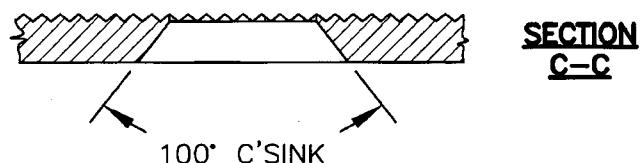
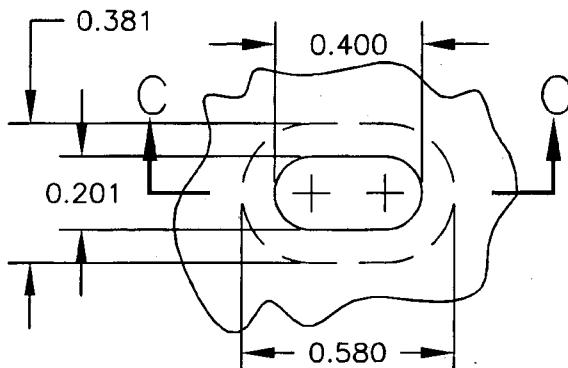
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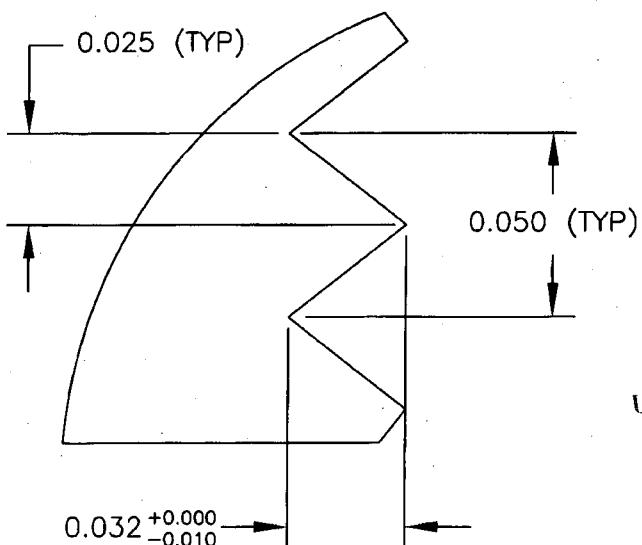
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CHECKED <i>CH</i>	APPROVED <i>-</i>	DRAWING NO. D3121	REV. E SHEET 3 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**DETAIL A:**  
**SLOT DETAIL**  
SCALE 2:1  
VIEW ROTATED



**RELEASED**  
07.11.07 *[Signature]*

**DETAIL B:**  
**RIDGE DETAIL**  
PARTIAL SECTION  
SCALE 1:20



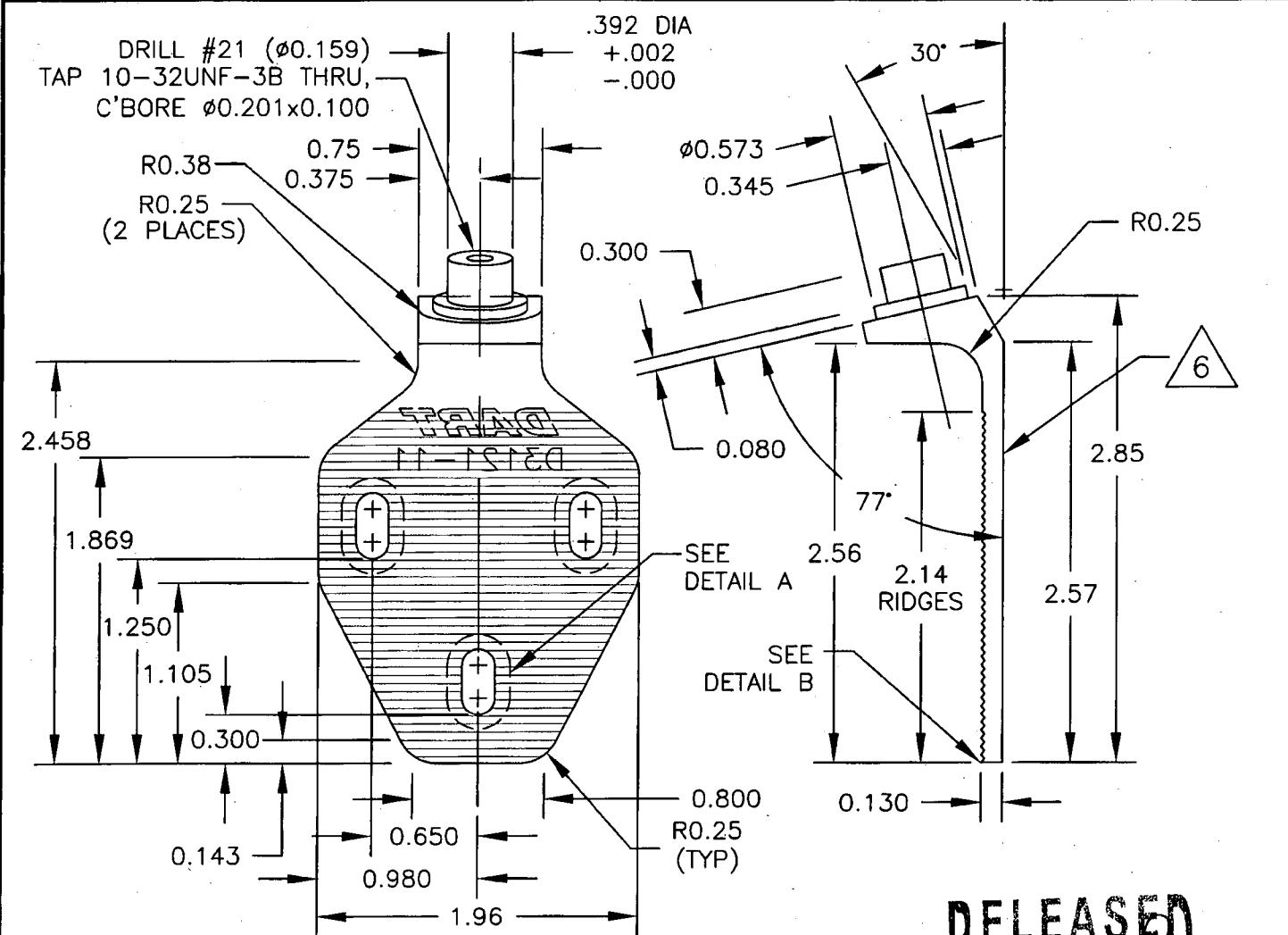
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DATE 07.11.07	TITLE BRACKET ASSEMBLY	SCALE 1:1	



**RELEASED**  
07.11.07 *MW*

D3121-11 BRACKET

1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

4) BREAK ALL SHARP EDGES 0.005 TO 0.015

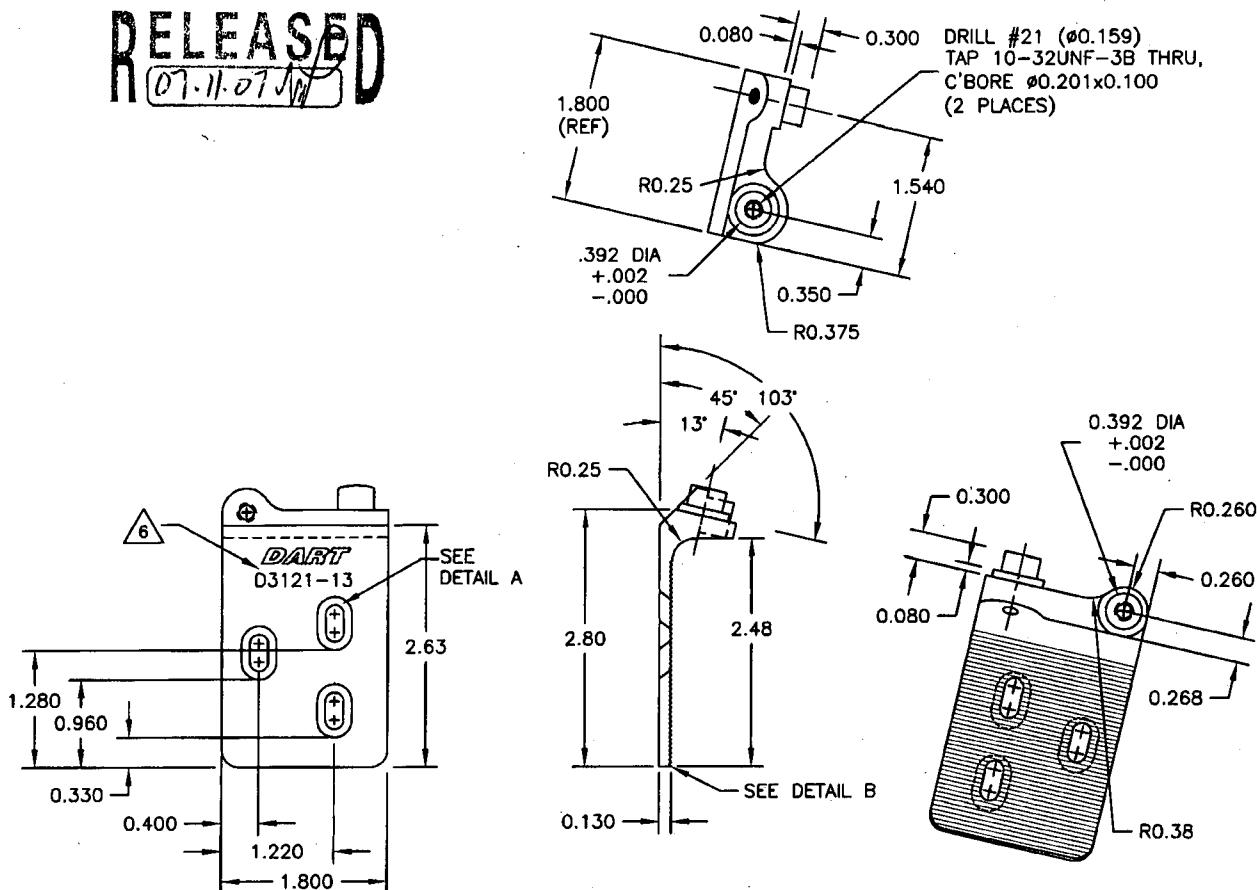
5) ENGRAVE DART P/N & LOGO AS SHOWN

6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

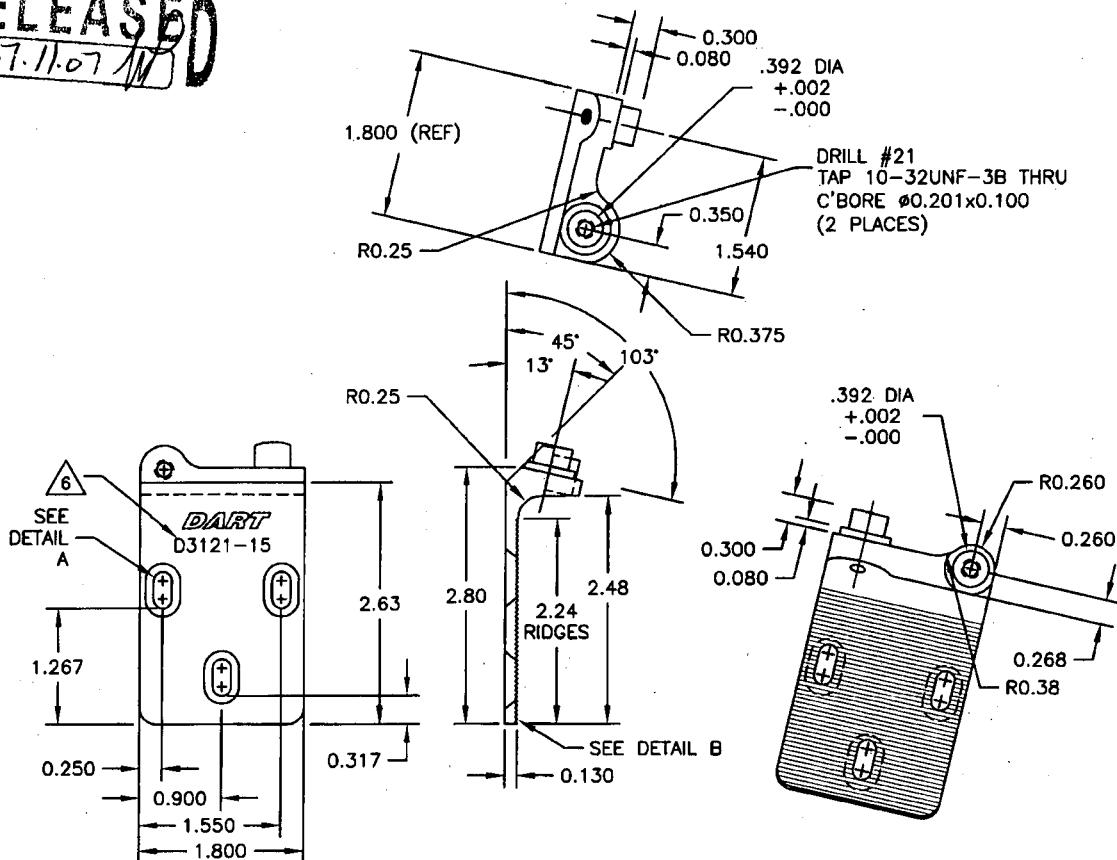
**RELEASED**  
(07.11.07)**D3121-13 BRACKET (SHOWN)****D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE 07.11.07	TITLE BRACKET ASSEMBLY	SCALE 1:2	

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07.11.07

**D3121-15 BRACKET (SHOWN)**  
**D3121-16 BRACKET (OPPOSITE)**

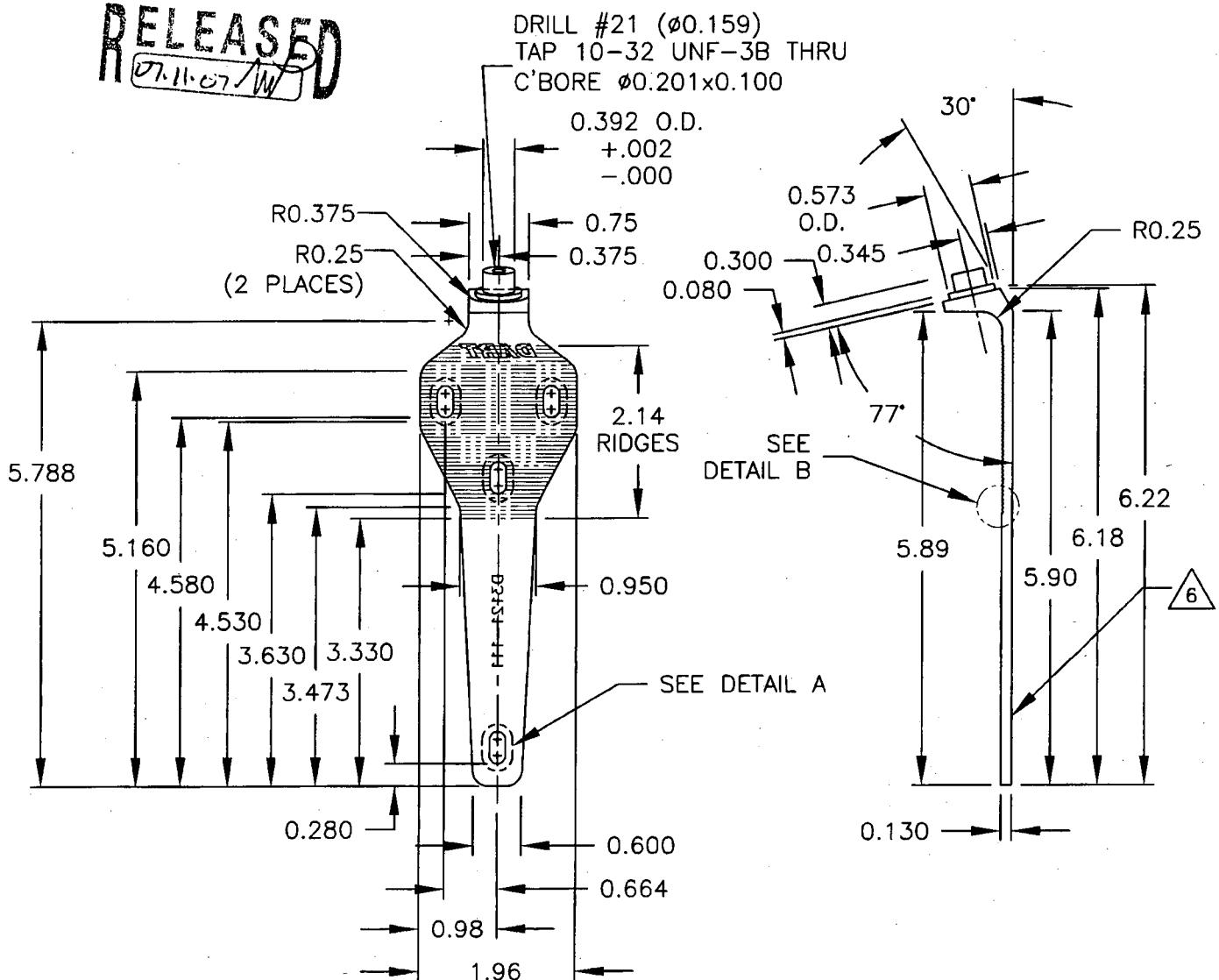
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
 MIN ULTIMATE TENSILE = 150 ksi  
 MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE	1:2

RELEASED  
07.11.07 / W



**D3121-111 BRACKET**

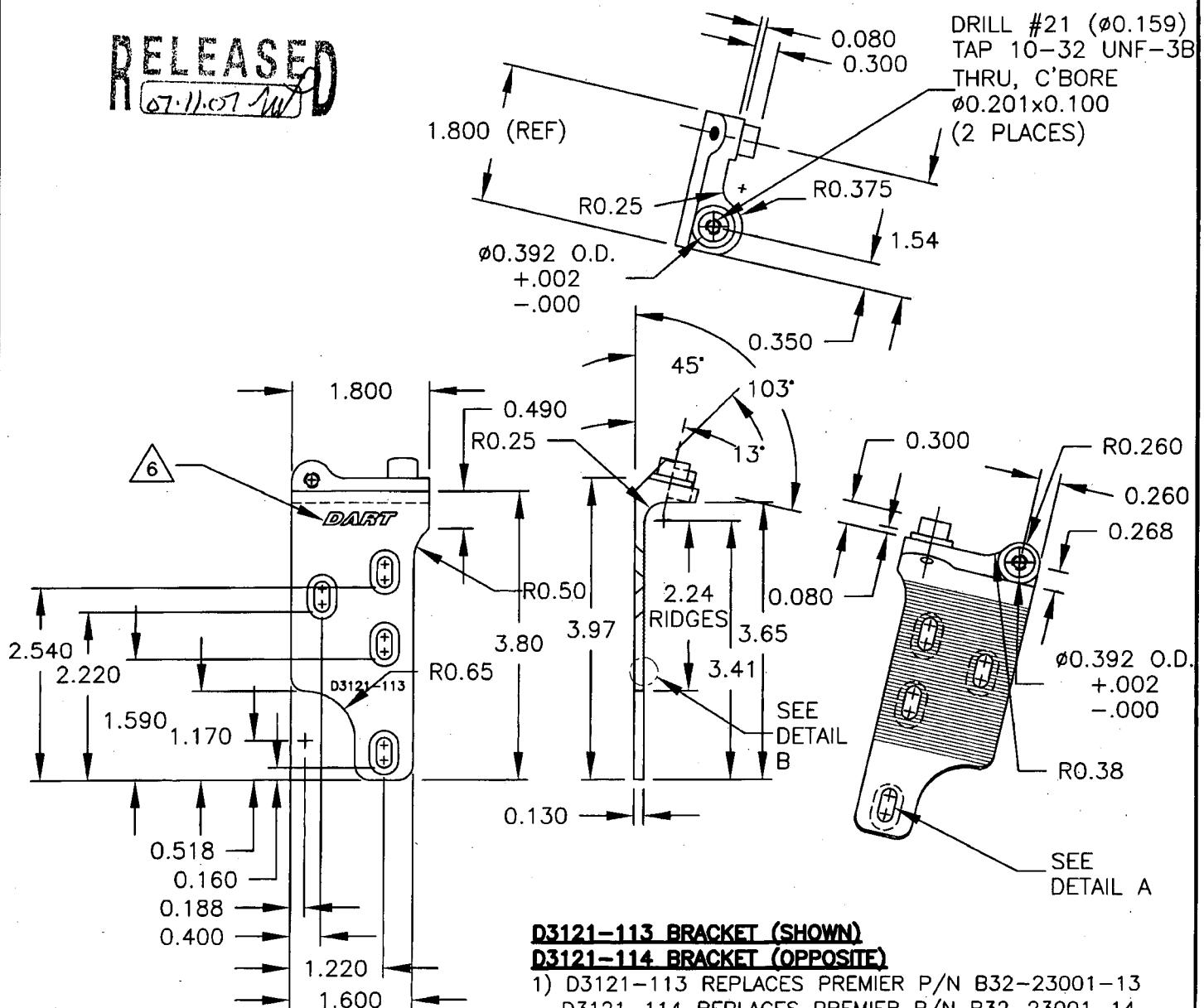
- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2	

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07-11-07

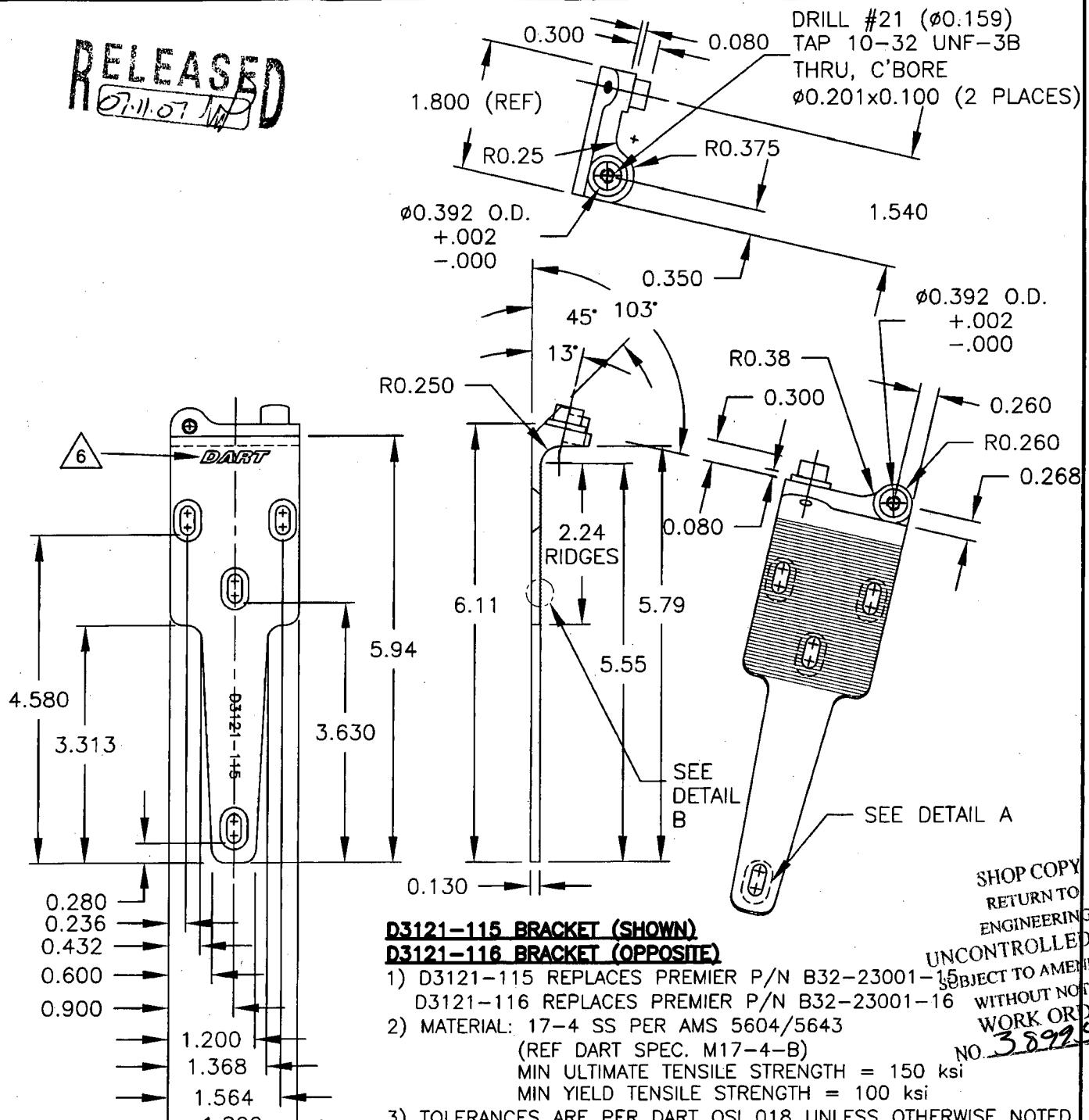


D3121-113 BRACKET (SHOWN)  
D3121-114 BRACKET (OPPOSITE)

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13  
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

**DART**

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DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

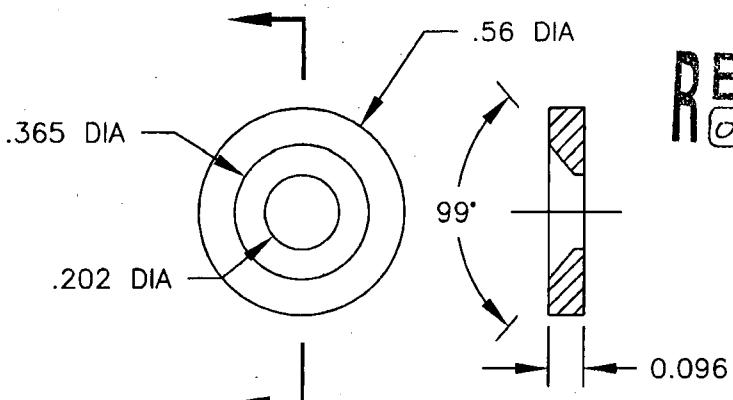
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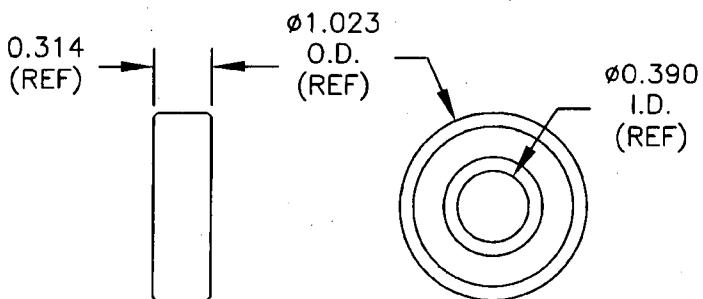
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CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1



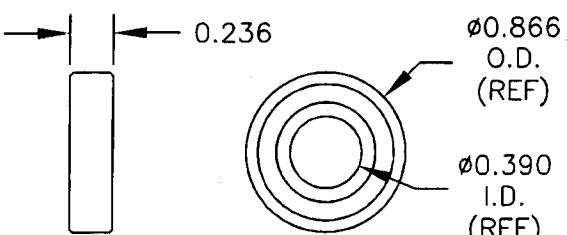
#### D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



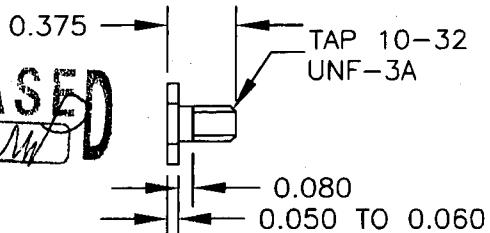
#### D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM  
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



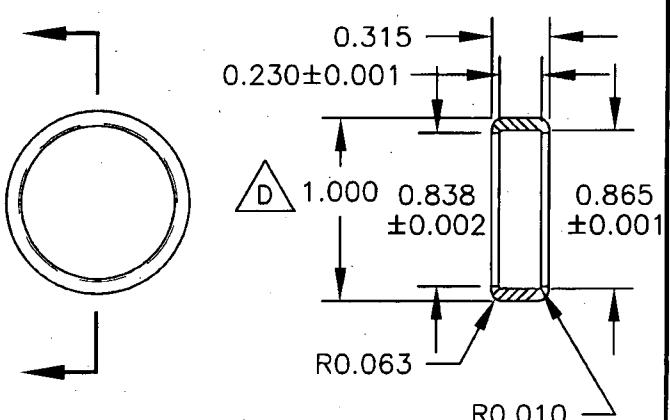
#### D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z  
OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES



#### D3121-21 BOLT (SCALE 1:1)

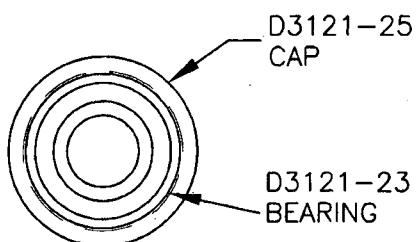
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



#### D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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NO. *38995*



#### D3121-241 BEARING ASSEMBLY (SCALE 1:1)

GENERAL BEARING SERVICE • Inc

GST # R101979094

SOLD TO: DART AEROSPACE LTD.  
1270, ABERDEEN STREET  
HAWKESBURY, ON. K6A-1K7

SALE MADE BY: DR  
SHIP VIA:

CUSTOMER ORDER #: 00006265

ORDER DATE: MAY 5, 2008

PST LICENCE: 6122-5267

PRODUCT	DESCRIPTION	SOLD	SHIP	PRICE	EXTENSION
6900-2Z	BALL BEARING	40	40	4.89	195.60
6900-2Z	BALL BEARING	200	200	4.89	978.00
				G.S.T.	58.68

PACKING SLIP NO.: 593070-0

RECEIVED BY

*Robert Gerald Pace*

1304220

Comments: AS PER DWG D3121 REV. E  
SKF P/N:61900-2Z OR KML P/N: 6900-ZZ  
B38995

THIS FORM MUST BE COMPUTER PRINTED TO BE VALID E & OE  
DOIT ÊTRE IMPRIMÉ PAR ORDINATEUR POUR ÊTRE VALIDE E & OE